

Amendments to the Claims

What is claimed is:

1-29 Cancelled.

30. (Original) A liquid film lubricant comprising:
an oil; and
a surfactant,

wherein the liquid film lubricant has the characteristic that the coefficient of friction is reduced when the liquid film lubricant is wetted as compared to the coefficient of friction of the liquid film lubricant is unwetted.

31-61 Cancelled.

62. (New) The liquid film lubricant of claim 30, wherein the oil is selected from the group consisting of vegetable oils, blown vegetable oils, polymers of vegetable oils, animal oils, and blown animal oils, and mixtures thereof.

63. (New) The liquid film lubricant of claim 30, wherein the oil is selected from the group consisting of blown canola oil, blown fish oil, canola oil, blown rapeseed oil, naphthenic oil, and mixtures thereof.

64. (New) The liquid film lubricant of claim 30, wherein the oil is selected from oils having a kinematic viscosity, measured at 40° C, that is at least 2.5 stokes.

65. (New) The liquid film lubricant of claim 30, wherein the surfactant is a non-ionic surfactant.

66. (New) The liquid film lubricant of claim 65, wherein the surfactant is selected from the group consisting of vegetable oil ethoxylates, ethoxylates of alkyl alcohols, ethoxylates of acetylenic diols, block copolymers of ethylene and propylene oxides, ethoxylates of alkyl carboxylates, alkyl polyglycosides, and mixtures thereof.

67. (New) The liquid film lubricant of claim 30, wherein the surfactant is present in an amount of about 1.0% to 5% of the total weight of the liquid film composition.

68. (New) A liquid die-side lubricant useful in hydroforming processes that utilize a pressure-side fluid, said liquid die-side lubricant comprising:

at least one oil; and

a surfactant dissolved or dispersed in said oil,

said lubricant having a resistance to damage, by contact with pressure-side fluid, to lubrication properties of said lubricant such that a coefficient of friction, measured after said contact, does not exceed an initial coefficient of friction measured under the same conditions prior to said contact by an amount that is more than about 50 percent.

69. (New) The liquid die-side lubricant of claim 68, wherein the at least one oil is a mixture of ethoxylated castor oil and one or more of blown canola oil, blown fish oil, canola oil, blown rapeseed oil, and naphthenic oil.

70. (New) The liquid die-side lubricant of claim 68, wherein the coefficient of friction, measured after said contact, does not exceed the initial coefficient of friction measured under the same conditions prior to said contact.

71. (New) The liquid die-side lubricant of claim 68, wherein the oil is selected from the group consisting of vegetable oils, blown vegetable oils, polymers of vegetable oils, animal oils, and blown animal oils, and mixtures thereof.

72. (New) The liquid die-side lubricant of claim 68, wherein the oil is selected from the group consisting of blown canola oil, blown fish oil, canola oil, blown rapeseed oil, naphthenic oil, and mixtures thereof.

73. (New) The liquid die-side lubricant of claim 68, wherein the oil is selected from oils having a kinematic viscosity, measured at 40° C, that is at least 2.5 stokes.

74. (New) The liquid die-side lubricant of claim 68, wherein the surfactant is a non-ionic surfactant.

75. (New) The liquid die-side lubricant of claim 74, wherein the surfactant is selected from the group consisting of vegetable oil ethoxylates, ethoxylates of alkyl alcohols, ethoxylates of acetylenic diols, block copolymers of ethylene and propylene oxides, ethoxylates of alkyl carboxylates, alkyl polyglycosides, and mixtures thereof.

76. (New) The liquid die-side lubricant of claim 68, wherein the surfactant is present in an amount of about 1.0% to 5% of the total weight of the liquid die-side composition.

77. (New) A liquid die-side lubricant useful in hydroforming processes that utilize a pressure-side fluid, said liquid die-side lubricant comprising ethoxylated castor oil and at least oil selected from the group consisting of blown canola oil, blown fish oil, canola oil, blown rapeseed oil, naphthenic oil, wherein the lubricant has a resistance to damage, by contact with pressure-side fluid, to lubrication properties of said lubricant such that a coefficient of friction, measured after said contact, does not exceed an initial coefficient of friction measured under the same conditions prior to said contact by an amount that is more than about 50 percent.